

Step 3/4

Work Order ID 57587

April 9, 2010 11:22:35 AM



Page 1

Item ID: D3608-3

Accept



Setup Start



Revision ID:

Item Name: Upper Doubler

Stop



Start Date: 4/09/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/13/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: ✓

Date: _____

Tooling: _____

Date: _____

Run Start



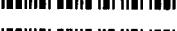
QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3608	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

HB 10-4-12

FLOW CNC Waterjet

1-Cut as per Dwg D3608

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

(6)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

HB 10-4-17

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

S. b. 4/12

(16)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57587

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Item ID: D3608-3**Accept****Setup Start****Revision ID:****Item Name:** Upper Doubler**Stop****Start Date:** 4/09/10 **Start Qty:** 4.00**Cust Item ID:****Required Date:** 4/13/10 **Req'd Qty:** 4.00**Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

150

Identify as per dwg & Stock Location: 175

0.00

4/04/22 E

Packaging

Packaging

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

*10/04/23 A**MF 10-4-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57587



Parent Item: D3608-3



Parent Item Name: Upper Doubler

Start Date: 4/09/10

Required Date: 4/13/10

Comments: IPP Rev:A New Issue 07-03-26 JLM

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 08-10-15 preliminary issue DD verified by:EC

IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC

IPP

Rev:D 10.02.16 rev.B as per dwg DD verified by:EC

M304S20GA



Purchased No

100

sf

79.0000

3.1124



304/316 .040 Sheet

5

AB 10-4-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT20	79	
112885	15	112885
113062	64	

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	52587
Description: Upper Doubler		Part Number:	D3608-3
Inspection Dwg: D3608	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	Y			
1.820	+/-0.010	1.816	Y			
0.500	+/-0.010	.498	Y			
1.325	+/-0.010	1.328	T			
7.950	+/-0.010	7.951	Y			
11.50	+/-0.030	11.508	Y			
2.50	+/-0.030	2.508	Y			
3.750	+/-0.010	3.752	T			
1.250	+/-0.010	1.251	S			
8.50	+/-0.030	8.499	U			
0.75	+/-0.030	.753	Y			
2.46	+/-0.030	2.463	Y			
6.45	+/-0.030	6.444	Y			
6.51	+/-0.030	6.509	Y			
11.63	+/-0.030	11.625	Y			
2.53	+/-0.030	2.531	Y			
1.41	+/-0.030	1.415	Y			
3.750	+/-0.010	3.753	T			
1.250	+/-0.010	1.251	Y			
8.56	+/-0.030	8.560	Y			
2.53	+/-0.030	2.533	Y			
0.040	+/-0.010	.037	Y			

Measured by:	LB	Audited by:	S	Prototype Approval:	N/A
Date:	10-4-12	Date:	10/08/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	M

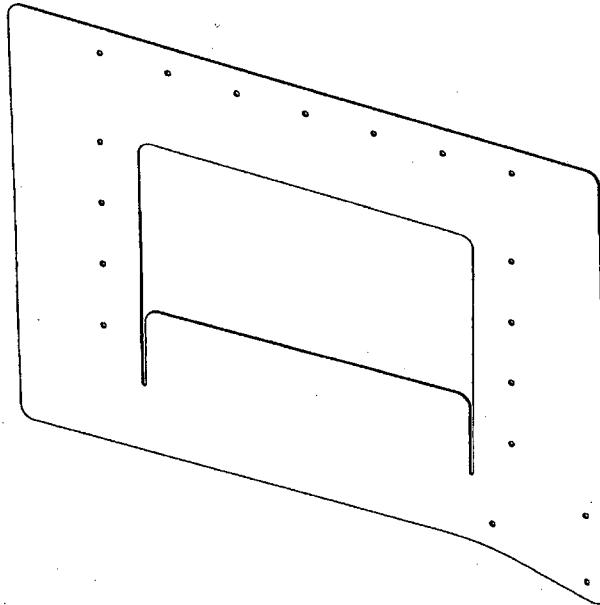
8 7 6 5 4 3 2 1

D

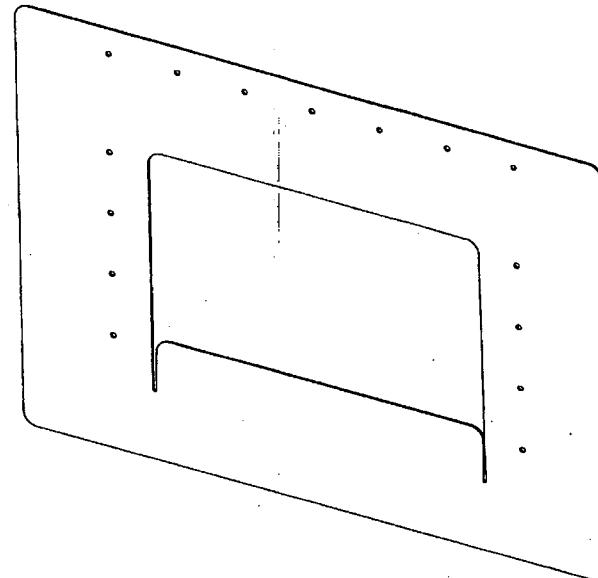
C

B

A



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

RELEASED
2010-02-10

W2
52587

8

7

6

5

4

3

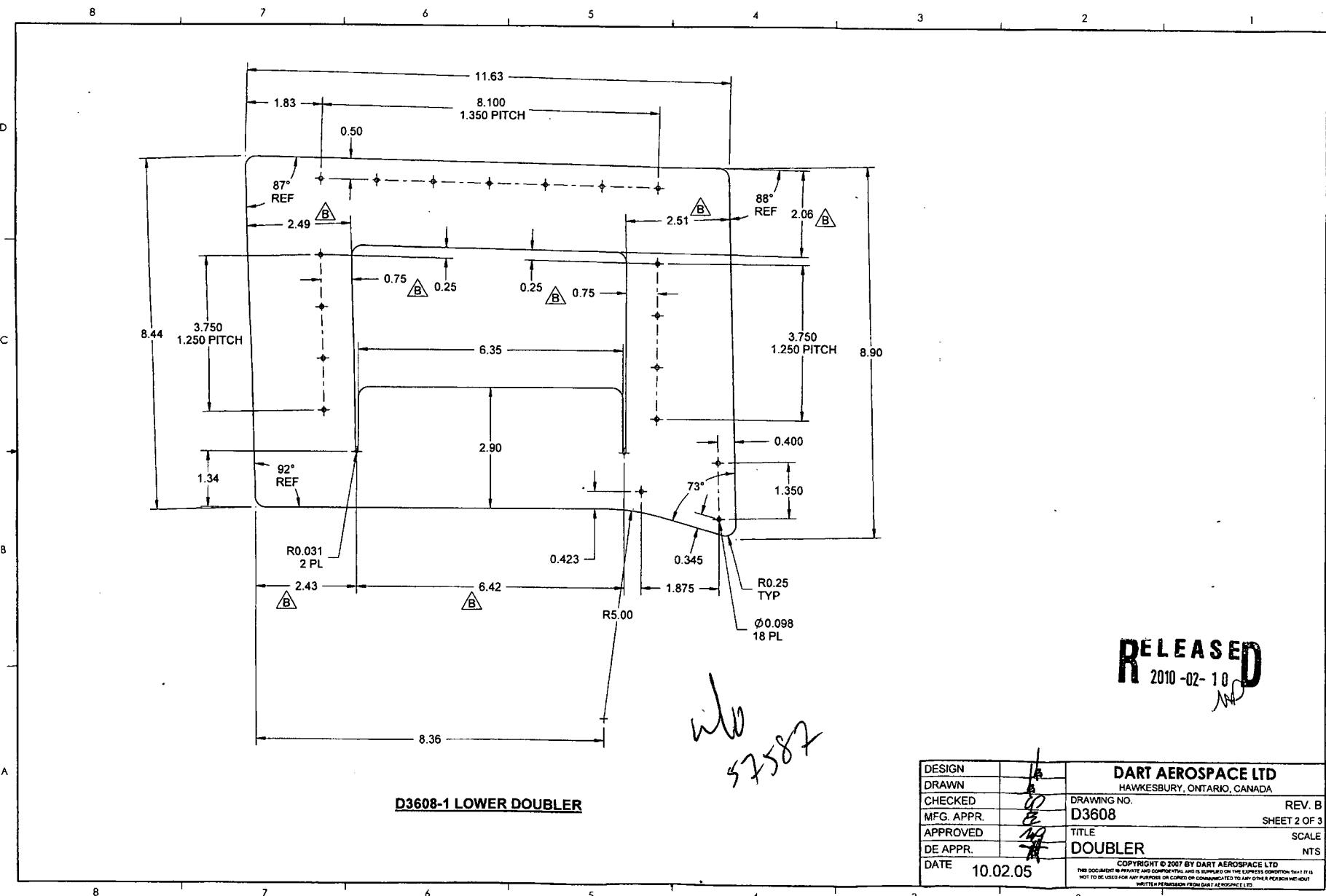
2

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NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA

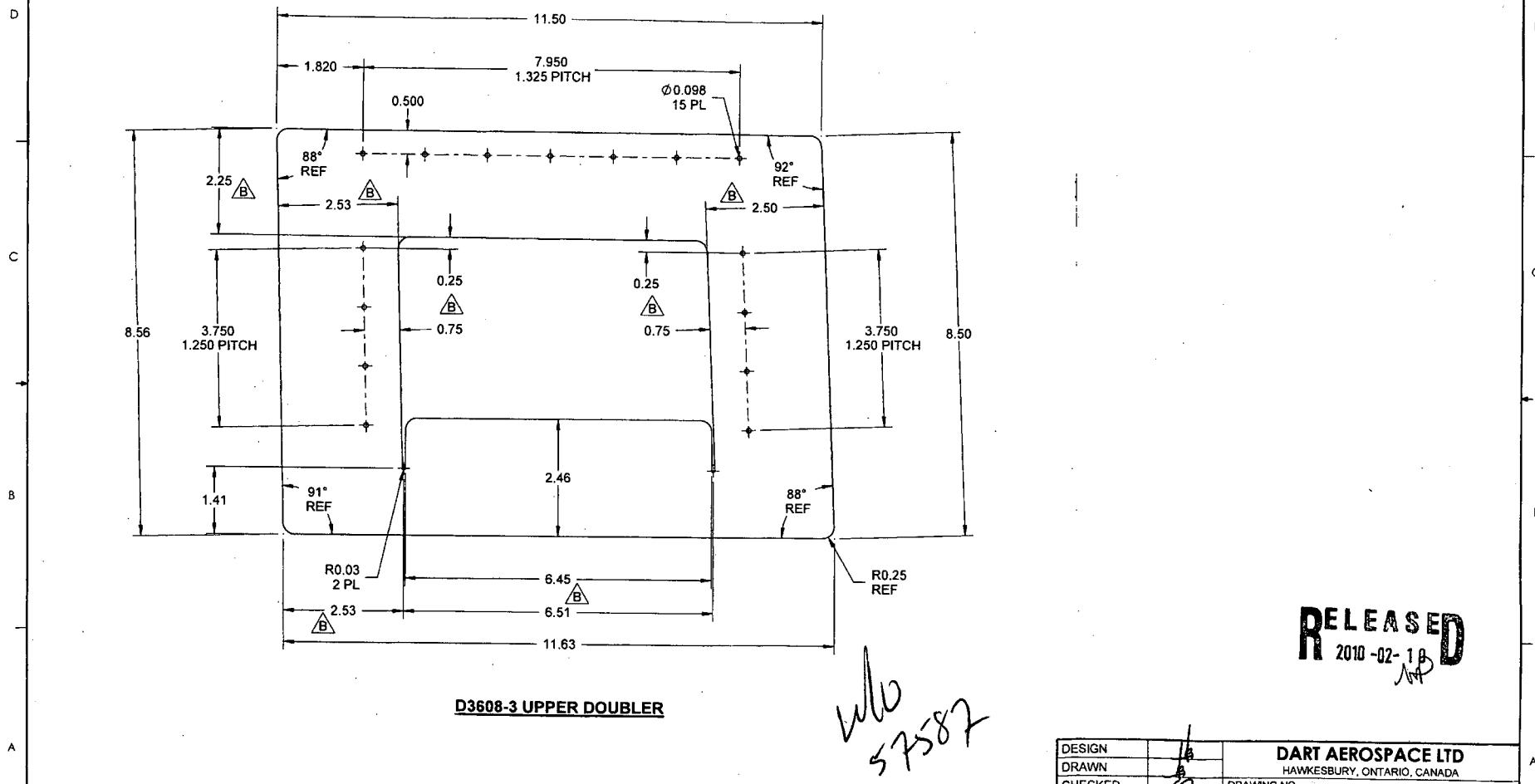
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.80 lbs EACH

B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD. BUMPS REMOVED FROM TOP-3F. DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097.	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>W</i>	DART AEROSPACE LTD	
DRAWN	<i>W</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>W</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>W</i>	D3608	SHEET 1 OF 3
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	DOUBLER	NTS
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MFG. APPR.	<i>10</i>	D3608	SHEET 2 OF 3
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	DOUBLER	NTS
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8 7 6 5 4 3 2 1



RELEASED
2010-02-18
M

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CHECKED	2	DRAWING NO.
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APPROVED	1	SHEET 3 OF 3
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